

WE CLAIM:

1. An integrated circuit fabricated in semiconductor
5 material of a first conductivity type, said circuit
having at the surface at least one lateral MOS
transistor surrounded by an electrical isolation
region, comprising:

10 a source and a drain, each having at the surface a
region of the opposite conductivity type
extending to the centrally located gate, defining
the active area of said transistor;

15 a well of opposite conductivity type surrounding
said source and drain, extending from said
surface deep into said semiconductor material of
said first conductivity type;

20 a semiconductor region within said semiconductor
material of said first conductivity type
surrounded by said well, said semiconductor
region having a resistivity higher than the
remainder of said semiconductor material; and
a layer of said opposite conductivity type buried in
said semiconductor region;

25 said layer extending laterally to said wells,
thereby electrically isolating the near-surface
portion of said semiconductor region from the
remainder of said semiconductor material, and
enabling said MOS transistor to operate as an
electrically isolated high-voltage I/O transistor
30 for circuit noise reduction, while having low
drain junction capacitance;

said layer extending vertically deeper from said

surface than said electrical isolation region,
thereby enabling a separate contact to said
electrically isolated near-surface portion of
said semiconductor region.

- 5 2. The circuit according to Claim 1 wherein said
semiconductor material is selected from a group
consisting of silicon, silicon germanium, gallium
arsenide, and any other semiconductor material used in
integrated circuit fabrication.
- 10 3. The circuit according to Claim 1 wherein said
semiconductor of the first conductivity type is made of
p-type silicon in the resistivity range from about 1 to
50 Ωcm , and said source, drain, wells, and buried layer
are made of n-type silicon.
- 15 4. The circuit according to Claim 1 wherein said
semiconductor of the first conductivity type is a
semiconductor epitaxial layer.
5. The circuit according to Claim 1 wherein said
semiconductor of the first conductivity type has a
20 dopant species selected from a group consisting of
boron, aluminum, gallium, and indium, while said
source, drain, their extensions, and said buried layer
have a dopant species selected from a group consisting
of arsenic, phosphorus, antimony, and bismuth.
- 25 6. The circuit according to Claim 1 wherein said
semiconductor of the first conductivity type is made of
n-type silicon in the resistivity range from about 5 to
50 Ωcm , and said source, drain, and their extensions
are made of p-type silicon.
- 30 7. The circuit according to Claim 1 wherein said
semiconductor of the first conductivity type has a

dopant species selected from a group consisting of arsenic, phosphorus, antimony, bismuth, and lithium, while said source, drain, their extensions, and said buried layer have a dopant species selected from a group consisting of boron, aluminum, gallium, indium, and lithium.

8. An integrated circuit fabricated in semiconductor material of a first conductivity type, said circuit having at the surface at least one lateral MOS transistor surrounded by an electrical isolation region, comprising:

a source and a drain, each having at the surface a region of the opposite conductivity type extending to the centrally located gate, defining the active area of said transistor;

a well of opposite conductivity type surrounding said source and drain, extending from said surface deep into said semiconductor material of said first conductivity type;

a semiconductor region within said semiconductor material of said first conductivity type surrounded by said well, said semiconductor region having a resistivity higher than the remainder of said semiconductor material; and

a layer of said opposite conductivity type buried in said semiconductor region;

said layer extending laterally to said wells, thereby electrically isolating the near-surface portion of said semiconductor region from the remainder of said semiconductor material, and enabling said MOS transistor to operate as an electrically isolated high-voltage I/O transistor

for circuit noise reduction, while having low drain junction capacitance;

said layer extending vertically from said surface not as deep as said electrical isolation region, thereby enabling contacts to said electrically isolated near-surface portion of said semiconductor region in the shape of body-tied source or of angular-structured gate.

9. The circuit according to Claim 8 wherein said body-tied source is configured to provide a dual-function contact region to said MOS transistor source, and to said electrically isolated near-surface portion of said semiconductor region.

10. The circuit according to Claim 8 wherein said angular-structured gate of said MOS transistor is configured to include an H-shape or a T-shape such that its directly adjacent regions provide contacts to said source, drain, and near-surface portion of said semiconductor region.

11. A method of fabricating a buried n-type layer connecting two n-wells in a p-type semiconductor region, electrically isolating the near-surface p-type semiconductor portion suitable for fabricating a high-voltage I/O nMOS transistor, comprising the steps of:

depositing a photoresist layer over the surface of said p-type semiconductor region, and opening a window in said layer, exposing the surface area between said n-wells;

implanting, at low energy, n-doping ions through said window, creating shallow n-doped layers under said surface, suitable as extended source and drain of said transistor; and

implanting, at high energy and high dose, n-doping ions into said p-type semiconductor through said window, creating a deep region having a net n-type doping between, and continuous with, said n-wells, and further creating a near-surface p-region having a doping concentration lower than that of the remainder of said p-type semiconductor region.

12. A method of fabricating an electrically isolated high-voltage I/O nMOS transistor in the surface of p-type semiconductor material, comprising the steps of:

forming two nested pairs of non-conductive electrical isolation regions into said p-type semiconductor material, the inner pair defining the lateral boundaries of said nMOS transistor active area, and the outer pair defining the area between n-wells;

implanting p-doping or n-doping ions to adjust the background doping level of the sub-surface region

of said p-type semiconductor material;
forming n-wells into said adjusted p-type semiconductor material;

depositing over said surface a layer of insulating material suitable as gate dielectric, covering said transistor area;

depositing a layer of poly-silicon or other conductive material onto said insulating layer; protecting a portion of said poly-silicon and etching the remainder thereof, defining the gate area of said transistor;

depositing a first photoresist layer and opening a window therein, exposing the surface of said area

between said outer isolation regions;
implanting, at low energy, n-doping ions into said
exposed surface area, creating shallow n-doped
layers under said surface, suitable as extended
5 source and drain of said transistor;
implanting, at high energy and high dose, n-doping
ions into said exposed surface area, creating a
deep region under said surface having a net n-
type doping between, and continuous with, said n-
10 wells, and further creating a p-region having a
doping concentration lower than that of the
remainder of said adjusted p-type region;
removing said first photoresist layer;
depositing conformal insulating layers of an
15 insulator, such as silicon nitride or silicon
dioxide, over said surface and directional plasma
etching said insulating layers so that only side
walls around the poly-silicon gate remain;
depositing a second photoresist layer and opening a
20 window therein, exposing the surface of said area
between said outer isolation regions;
implanting, at medium energy, n-doping ions into
said exposed surface area, creating an n-doped
region that extends to a medium depth under said
25 surface, suitable as deep source and drain of
said transistor;
removing said second photoresist layer; and
forming an electrical contact region to said p-
region of lower doping concentration.

- 30 13. The method according to Claim 12 further including the
process step of implanting, at high energy and low
dose, p-doping ions for controlling the location and

extent of said deep n-type region.

14. The method according to Claim 12 further including the process step of forming a p+-region as said electrical contact region to said p-region of lower doping concentration, said p+-region located close to, but electrically isolated from, the source of said nMOS transistor.
15. The method according to Claim 12 further including the process step of forming a body-tied source providing a dual-function contact region to said nMOS transistor source and to said electrically isolated near-surface portion of said semiconductor region.
16. The method according to Claim 12 further including the process step of forming an angular-structured gate, configured to include an H-shape or a T-shape such that its directly adjacent regions provide contacts to said source, drain, and near-surface portion of said semiconductor region.
17. The method according to Claim 12 wherein the thickness of said first photoresist layer is larger than a thickness solely required to block said low-energy ion implant.
18. The method according to Claim 12 further comprising the step of annealing said high energy implant at elevated temperature.
19. The method according to Claim 12 comprising the modified process step of implanting said n-doping ions at high energy after said process step of implanting said n-doping ions at medium energy.
20. The method according to Claim 12 wherein said p-type semiconductor has a peak doping concentration between $4 \cdot 10^{17}$ and $1 \cdot 10^{18}$ cm⁻³ after said background

doping adjustment implant.

21. The method according to Claim 12 wherein said
implanting of low energy ions comprises ions having an
energy suitable for creating the junction at a depth
5 between 10 and 50 nm, and a peak concentration from
about $5 \cdot 10^{17}$ to $5 \cdot 10^{20} \text{ cm}^{-3}$.
22. The method according to Claim 12 wherein said
implanting of medium energy ions comprises ions having
an energy suitable for creating the junction at a depth
10 between 50 and 200 nm, and a peak concentration from
about $5 \cdot 10^{19}$ to $5 \cdot 10^{20} \text{ cm}^{-3}$.
23. The method according to Claim 12 wherein said
implanting of high energy ions comprises ions selected
in the energy range from about 400 to 700 keV such that
15 the peak concentration is at a different depth than
that of the p-type semiconductor, and in the dose range
of about $8 \cdot 10^{12}$ to $8 \cdot 10^{13} \text{ cm}^{-2}$ to overcompensate
the p-type semiconductor doping and to create a region
of the opposite conductivity type at a depth of more
20 than 200 nm.
24. The method according to Claim 12 wherein said net p-
type doping of low concentration comprises a peak
concentration of about 1 to $6 \cdot 10^{17} \text{ cm}^{-3}$ below the p-n
junctions of said transistor's deep source and drain
25 regions.
25. A method of fabricating a buried p-type layer
connecting two p-wells in an n-type semiconductor
region, electrically isolating the near-surface n-type
semiconductor portion suitable for fabricating a high-
30 voltage I/O pMOS transistor, comprising the steps of:
depositing a photoresist layer over the surface of
said n-type semiconductor region, and opening a

5 window in said layer, exposing the surface area
between said p-wells;
implanting, at low energy, p-doping ions through
said window, creating shallow p-doped layers
under said surface, suitable as extended source
and drain of said transistor; and
implanting, at high energy and high dose, p-doping
ions into said n-type semiconductor through said
window, creating a deep region having a net p-
type doping between, and continuous with, said p-
wells, and further creating a near-surface n-
region having a doping concentration lower than
that of the remainder of said n-type
semiconductor region.

15 26. A method of fabricating an electrically isolated high-
voltage I/O pMOS transistor in the surface of n-type
semiconductor material, comprising the steps of:
forming two nested pairs of non-conductive
electrical isolation regions into said n-type
semiconductor material, the inner pair defining
the lateral boundaries of said pMOS transistor
active area, and the outer pair defining the area
between p-wells;
implanting n-doping or p-doping ions to adjust the
background doping level of the sub-surface region
of said n-type semiconductor material;
forming said p-wells into said adjusted n-type
semiconductor material;
depositing over said surface a layer of insulating
material suitable as gate dielectric, covering
said transistor area;
depositing a layer of poly-silicon or other

conductive material onto said insulating layer;
protecting a portion of said poly-silicon and
etching the remainder thereof, defining the gate
area of said transistor;
5 depositing a first photoresist layer and opening a
window therein, exposing the surface of said area
between said outer isolation regions;
implanting, at low energy, p-doping ions into said
exposed surface area, creating shallow p-doped
10 layers under said surface, suitable as extended
source and drain of said transistor;
implanting, at high energy and high dose, p-doping
ions into said exposed surface area, creating a
deep region under said surface having a net p-
15 type doping between, and continuous with, said p-
wells, and further creating an n-region having a
doping concentration lower than that of the
remainder of said adjusted n-type region;
removing said first photoresist layer;
20 depositing conformal insulating layers of an
insulator, such as silicon nitride or silicon
dioxide, over said surface and directional plasma
etching said insulating layers so that only side
walls around the poly-silicon gate remain;
25 depositing a second photoresist layer and opening a
window therein, exposing the surface of said area
between outer isolation regions;
implanting, at medium energy, p-doping ions into
said exposed surface area, creating a p-doped
30 region that extends to a medium depth under said
surface, suitable as deep source and drain of
said transistor;

removing said second photoresist layer; and
forming an electrical contact region to said n-
region of lower doping concentration.

27. The method according to Claim 26 further including the
5 process step of implanting, and high energy and low
dose, n-doping ions for controlling the location and
extent of said deep p-type region.
28. The method according to Claim 26 further including the
process step of forming a n+-region as said electrical
10 contact region to said n-region of lower doping
concentration, said n+-region located close to, but
electrically isolated from, the source of said pMOS
transistor.
29. The method according to Claim 26 further including the
15 process step of forming a body-tied source providing a
dual-function contact region to said pMOS transistor
source and to said electrically isolated near-surface
portion of said semiconductor region.
30. The method according to Claim 26 further including the
20 process step of forming an angular-structured gate,
configured to include an H-shape or a T-shape such that
its directly adjacent regions provide contacts to said
source, drain, and near-surface portion of said
semiconductor region.
- 25 31. The method according to Claim 26 comprising the
modified process step of implanting said p-doping ions
at high energy after said process step of implanting
said p-doping ions at medium energy.
32. The method according to Claim 26 wherein said n-type
30 semiconductor has a peak doping concentration between
 $4 \cdot 10^{17}$ and $1 \cdot 10^{18}$ cm⁻³ after said background
doping adjustment implant.

33. The method according to Claim 26 wherein said
implanting of low energy ions comprises ions having an
energy suitable for creating the junction at a depth
between 10 and 50 nm, and a peak concentration from
5 about $5 \cdot 10^{17}$ to $5 \cdot 10^{20}$ cm⁻³.

34. The method according to Claim 26 wherein said
implanting of medium energy ions comprises ions having
an energy suitable for creating the junction at a depth
between 50 and 200 nm, and a peak concentration from
10 about $5 \cdot 10^{19}$ to $5 \cdot 10^{20}$ cm⁻³.

35. The method according to Claim 26 wherein said
implanting of high energy ions comprises ions selected
in the energy range from about 400 to 700 keV such that
the peak concentration is at a different depth than
15 that of the n-type semiconductor, and in the dose range
of about $8 \cdot 10^{12}$ to $8 \cdot 10^{13}$ cm⁻² to overcompensate
the n-type semiconductor doping and to create a region
of the opposite conductivity type at a depth of more
than 200 nm.

20

25

30